

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due	OTHER :							

Work Order ID 140713

140713

Page 2

Thursday, January 14, 2016 2:10:04 PM

Item ID: EA20469-24 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Rod
 Start Date: 1/15/2016 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 1/22/2016 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00							DAS 40 9-89
140									
QC	Memo	0.00							
Quality Control	100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT								16/01/26
180	Identify as per dwg & Stock Location: <u>Sold</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									JAN 26 2016 DAS 6 9-89
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.01							
Quality Control									JAN 26 2016 MCS

JAN 26 2016
MCS

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 1

Thursday, January 14, 2016 3:17:55 PM

Work Order ID: 140713

140713

Parent Item: EA20469-24

FA20469-24

Parent Item Name: Rod

Start Date: 1/15/2016

Required Date: 1/22/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-02-21 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NR0.750		Purchased		No			f	10.0174		0.664			

M4130NR0 750

4130 steel RD bar .750"

Location

Loc Qty

Loc Code

MAT032

10.017368

m132798

10.017368

0.885#

DAS

45

9-89

2016-01-25

DQA: _____ Date: _____



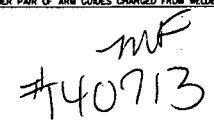
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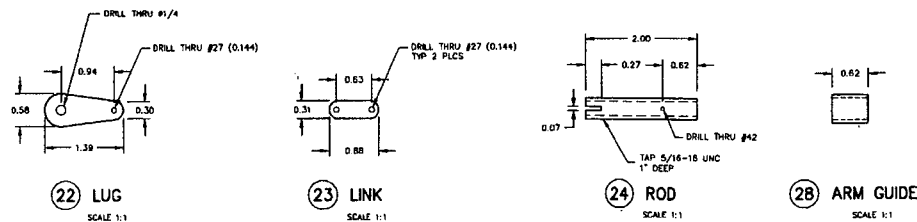
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	INNER PAIR OF ARM GUIDES CHANGED FROM WELDED TO RIVETED	DW	15 AUG 2000



NOTES FOR SHEET 3

1. WELDING OF 4130 STEEL ALLOY TO BE COMPLETED BY GTAW METHOD TO AWS D6.65. WELDING ROD SHALL CONFORM TO AWS E6474 OR LATER REVISION.
2. HEAT AND FORM DOOR PLATES (ITEM 76 & ITEM 27) TO SHAPE OF DOOR AND PLATE HOLE LOCATIONS ARE APPROXIMATE. MAINTAIN 20 EDGE DISTANCE.
3. THOROUGHLY DEGREASE, PRIME, AND PAINT ALL PIECES AFTER ASSEMBLY.
4. OUTER PAIR OF ARM GUIDES (ITEM 28) WELDED TO DOOR PLATES AS SHOWN. INNER PAIR OF ARM GUIDES LEFT LOOSE UNTIL ASSEMBLY WITH DOOR AND THEN FASTENED TO ARM WITH CR3242-3 NUTS AFTER ARM ALIGNMENT.



QTY	DASH NO.	DESCRIPTION	PART NO.	MATERIAL	STOCK SIZE
1	20	ARM	E202485-29	4130 STEEL	MIL-T-8736 63/8 O.D. x 0.093 WALL
4	28	ARM GUARD	E202485-28	4130 STEEL	MIL-T-8736 61/2 O.D. x 0.063 WALL
1	27	DOOR PLATE	E202485-27	MILD STEEL	0.063" SHEET
20	26	DOOR PLATE	E202485-26	MILD STEEL	0.063" SHEET
1	25	ARM SUB-ASSEMBLY	E202485-25		
1	24	ROD	E202485-24	4130 STEEL	MIL-T-8736 65/8 O.D. x 0.093 WALL
23	23	LINE	E202485-23	4130 STEEL	MIL-S-18729 0.063" SHEET
2	22	LUG	E202485-22	4130 STEEL	MIL-S-18729 0.063" SHEET
1	21	DOOR COVER PANEL	E21484-21		
20	FUGIT MANUAL SUPPLEMENT	2148, 2148-1	E21728-20		
20	FUGIT MANUAL SUPPLEMENT	"212, 412	E21728-20		
20	FUGIT MANUAL SUPPLEMENT	205A, 205A-1	E202485-20		
1	20	FUGIT MANUAL SUPPLEMENT	205A		
1	19	EAGLE SERVICE INSTRUCTION	E202485-19		
1	18	DOOR INNER SKIN	E202485-18		
1	17	ANGLE	E202485-17		
1	16	ARM REST ASSEMBLY	E202485-16		
1	15	INSTRUMENT PANEL	E202485-15		
1	14	WINDOW BEZEL	E202485-14		
1	13	INSTRUMENT WINDOW	E202485-13		
1	12	FORWARD ROD	E202485-12		
1	11	ANGLE	E202485-11		
1	10	REARWARD RIB	E202485-10		
1	9	ANGLE	E202485-09		
1	8	FLACARD - INSTRUMENT PANEL	E202485-08		
1	7	ANGLE	E202485-07		
1	6	ALUMINUM STOP	E202485-06		
1	5	RUBBER STOP	E202485-05		
4	4	DOOR LATCH ASSEMBLY	E202485-04		
1	3	PLEXIGLASS BUBBLE WINDOW	E202485-03		
2	1	INSTALLATION - DOOR MOUNTED INSTRUMENTS			
1	1	INSTALLATION - BUBBLE WINDOW			

[illegible]

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